

Work Order ID 50513

July 13, 2009 10:20:59 AM



Page 1

Item ID: D2855

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cap

Start Date: 7/13/09

Start Qty: 30.00

50



Cust Item ID:

Required Date: 7/20/09

Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2855

Rev A

100



Purchasing

PURCHASING

0.00

Memo

0.00

Purchasing

Issue P/O: 10084 Cast per Dwg D2855 Material Release Note Required

CL 09/07/13 50

110



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure Material Release Note is attached

PC 9/17/27 (52)

120



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Quality Control

=> 8 02/07/08

center (52) f

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Page 2

Item ID: D2855

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Item Name: Cap

Setup Start

Stop

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Drill as per Dwg D2855 using DT8235 1/2- Open holes to 19/64" 1/3- Deburr

Ep09/07/29 (52)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

25 509/07/29 (52) ✓

150

0.00



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

Powder Coating

START TIME: 9:30AM OVEN TEMPERATURE: 320°F
FINISH TIME: 10:00AM

26 09-07-29 (52)

12112140

Work Order ID 50513

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Page 3

Item ID: D2855

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Item Name: Cap

Start Date: 7/13/09

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Required Date: 7/20/09

Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-07-29. (52)

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

BR 09-07-29 (52)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S o 9/17/09 (52) 4

Work Order ID 50513

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Page 4

Item ID: D2855

Accept



Setup Start



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Stop



Item Name: Cap

Start Date: 7/13/09

Start Qty: 30.00



Cust Item ID:

Required Date: 7/20/09

Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location:

FP-6

0.00

BL 09-07-29 (52)



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

09/07/29 HJ



QC

Memo

0.00

Quality Control

MF 09-07-29

Picklist Print

July 13, 2009 10:20:59 AM

Page 1

Work Order ID: 50513

Parent Item: D2855RevA

Parent Item Name: Cap

Comments:

Start Date: 7/13/09

Required Date: 7/20/09

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	877.0000	60.0000			



INSERT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

100895

100896

102018

110118

111529

111581

877

21

102

102

52

300

300

170

Each

0.0000

30.0000

D2855PRevA

Purchased

No



Cap

*M 110768

104 BR 09-07-29.

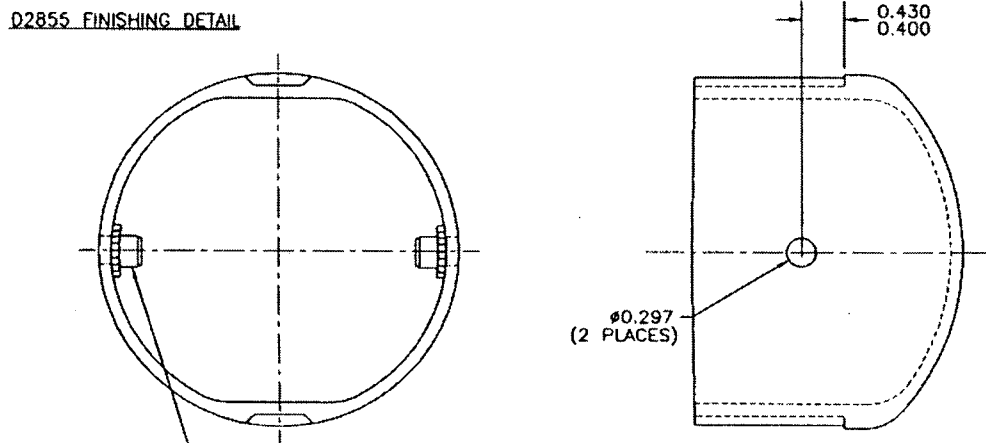
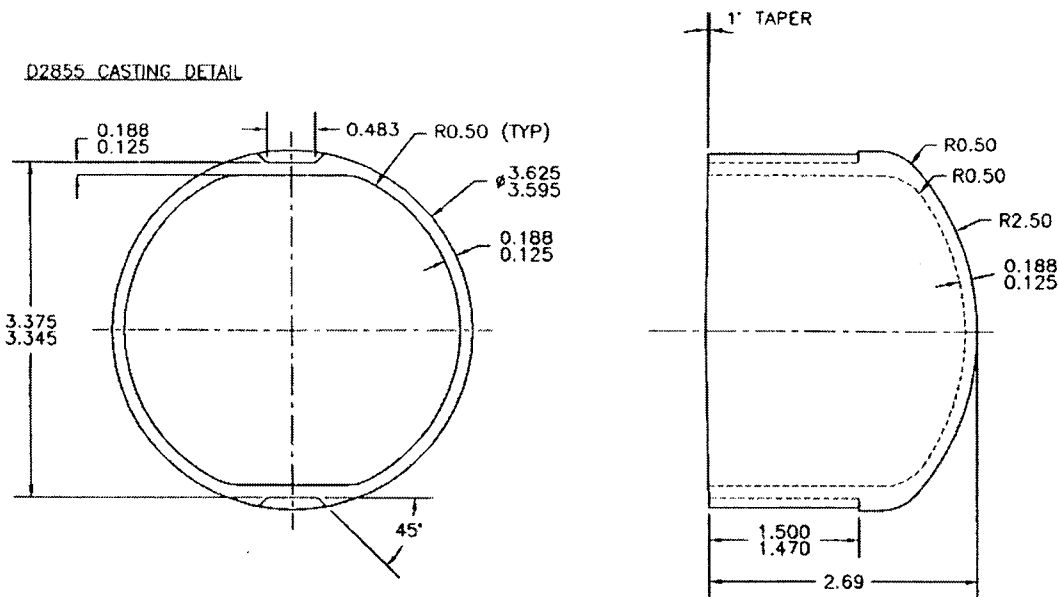
50513 MF 09-07-29



DESIGN	BY	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. A
CHECKED	APPROVED	DRAWING NO.	D2855	SHEET 1 OF 1
DATE		TITLE	CAP	SCALE
98.12.12				NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)		

RELEASED
11/18/12/14 DS

50513



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

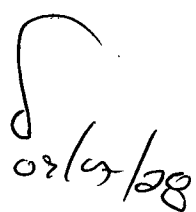
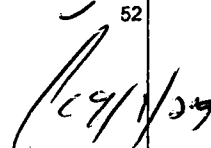
Aluminum Foundry Ltd

2225 Chemin St. Francois
Dorval, Québec H9P 1K3
Tel: (514) 683-9777
Fax: (514) 683-0376

Packing Slip

Packing Slip No.: 33089
Date: Jul 23, 2009
Page: 1

Sold to:		Ship to:	
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7		DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	
Order No.: 10084		Sold By:	
Shipped By: Fedex		Ship Date: Jul 23, 2009	
Tracking No.:			

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	52
<div style="text-align: center;">  02/07/08 </div>			<div style="text-align: center;">  09/11/09 </div>
Comment: 			

7CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

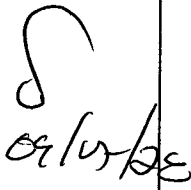
Packing
Date: **23/07/2009** Slip No. **33089**

Hawksbury, ON, K6A 1K7

Vôtre No. Commande **10084**
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
52pcs	D 2855 CAP	Z098046 	A356.2	ingot#20090102

Analyse
Analysis (as in ingot)

(Si)	7.17%	(Al)	balance
(Fe)	0.087%		
(Cu)	0.0024%		
(Mn)	0.0017%		
(Mg)	0.37%		
(Zn)	<0.001%		
(Ti)	0.16%		

Donne
Yield :

Résistance a la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :
Par/Per :

Coc-100



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10084

Purchase Order Date 7/15/09

PO Print Date 7/15/09

Page Number 1 of 1

Order From :

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA



Contact Name

Vendor Phone

514 683 9777

Vendor Fax

514 683 0375

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P A	Cap	7/24/09 Yes	50.00 Each	FedEx Economy	\$16.9000	\$845.00

Special Inst: AS PER DWG D2855 REV. A
B50513

PO Total:

\$845.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Rush order!

CY.
U

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 7/15/09